

Work Order ID 67608

Monday, March 28, 2011 2:29:16 PM



Page 1

Item ID: D3294-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket

Start Date: 3/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 10.00

Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

4-03-28

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3294

Rev C

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3294

Cut File D3294-3

Dwg Rev: C

Prog Rev: C

*grain direction on a 45 deg as per dwg**

2-Deburr if necessary

B11-4-5

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 11/04/10

(2)

130

0.00



Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary
2-Bend as per Dwg D3294
(Ensure angle is correct)

Sp 11/04/15

7

(2)

PTO

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11/04/18

(7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3294-1 PAR #: _____ Fault Category: Small Yaws NCR: ☒ Yes ☐ No DQA: HA Date: 11.05.02
11.562 Resolution: Scrap Disposition: Scrap QA: N/C Closed: CL Date: 11/05/03

NCR: <u>67608</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/04/15	130	2 piece crack during forming the band R.C Process - banding	<u>BSIUR</u>	Scrap, destroy - grain & band nucleus is good. - No material defects or due to damage	<u>SB</u> 11/04/18	<u>S</u> 11/04/18	<u>BSIUR</u>	<u>11/04/14</u>

NOTE: Date & initial all entries

Work Order ID 67608

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Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7 0 11-4-18

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 BL 11-4-18

170

0.00



Small Fab

Memo

0.00

Small Fab

1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

7 0/04/19 (7)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Stop



Item Name: Bracket

Start Date: 3/28/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 3/31/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sp 11/04/11

7

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

Start Time: 3:30
Oven Temperature: 820°
Finish Time: 4:00

7

BR 11-4-20

200

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7 11/04/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 5

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Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location: 212

0.00



Packaging

Memo

0.00

Packaging

11/4/21 5/72

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/21 [Signature]ME11-04-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

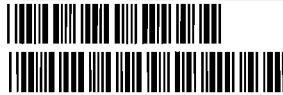
Monday, March 28, 2011 2:29:22 PM

Page 1

Work Order ID: 67608

Parent Item: D3294-1

Parent Item Name: Bracket



Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP ☐ A ☐ 04.08.24 ☐ New issue ☐ KJ/JLM ☐
 IPP Rev:B Now On Waterjet 07-03-26 JLM
 IPP Rev:C 08-07-16 Redesign part DD verified by:EC
 IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.080 		Purchased		No		100	sf	68.0000	1.8	18.94737	16.2		
2024-T3 .080 sheet											B11-4-5		

Location	Loc Qty	Loc Code
MAT022	68	
104921	1	
105411	6	
109424	4	
110347	2	
110908	3	
112331	3	
113796	7	
114025	28	
116604	14	

D3294-5



Doubler

Manufactured No

170 Each 9.0000

1

10

Location	Loc Qty	Loc Code
GA	9	
55331	9	

114025 x 6 = 10.8
 116604 x 3 = 5.4

SP 11/04/19

7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Page 2

Monday, March 28, 2011 2:29:22 PM

Work Order ID: 67608



Parent Item: D3294-1



Parent Item Name: Bracket

Start Date: 3/28/2011

Required Date: 3/31/2011

Start Qty: 10.00

Required Qty: 10.00

MS20470AD4-5

Purchased

No

170

Each

2,028.000

15

150



SS 11604/19

Rivet, Universal Head

Location

Loc Qty

Loc Code

ST319

2028

116410

353

116893 —

1675

105

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	67608
Description: Bracket Assembly		Part Number:	D3294-1
Inspection Dwg: D3294 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.129	X		V HB2	
Ø0.141	+0.005/-0.001	.141	X		V	
6.708	+/-0.010	6.710	X		T HB1	
1.118	+/-0.010	1.115	X		V	
5.590	+/-0.010	5.591	X		T	
1.118	+/-0.010	1.117	X		V	
13.563	+/-0.010	13.563	X		T	
1.043	+/-0.010	1.044	X		V	
0.625	+/-0.010	.624	X		V	
0.325	+/-0.010	.323	X		V	
0.300	+/-0.010	.296	X		V	
0.400	+/-0.010	.402	X		V	
6.000	+/-0.010	6.000	X		T	
1.000	+/-0.010	1.003	X		V	
17.124	+/-0.010	17.124	X		T	
16.13	+/-0.030	16.13	X		T	
7.27	+/-0.030	7.27	X		T	
11.97	+/-0.030	11.97	X		T	
8.37	+/-0.030	8.37	X		T	
20.05	+/-0.030	20.05	X		T	
12.98	+/-0.030	12.98	X		T	
14.59	+/-0.030	14.59	X		T	
11.66	+/-0.030	11.66	X		T	
0.080	+/-0.010	.079	X		V	

Measured by:	HB	Audited by:	S	Prototype Approval:	N/A
Date:	11-4-5	Date:	11/04/06	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

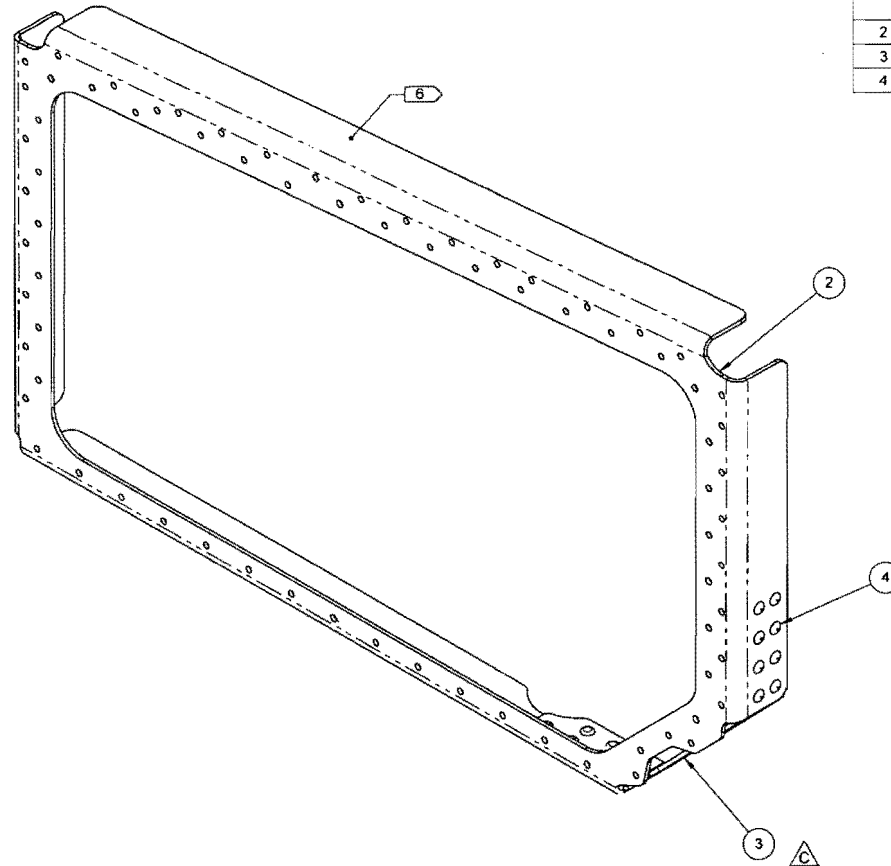
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -1	PART NUMBER	DESCRIPTION
1	X	D3294-1	BRACKET ASSEMBLY
2	1	D3294-3	BRACKET
3	1	D3294-5	DOUBLER
4	15	MS20470AD4-5	RIVET



D3294-1 BRACKET ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 016 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3294-1 AND B/N" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.83 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67608
PA110308

RELEASED
09/04/07 JHP

C	REMOVE FLANGE PREVIOUSLY ADDED. ADD -5 DOUBLER ZN A4-1, SHEET 5+6.	HS	09.03.24
B	CHANGE FLANGE FROM OUTSIDE TO INSIDE. ZN B4-1, C3-2. CHANGE GRAIN DIRECTION, ZN C4-2	HS	08.09.22
A	NEW ISSUE	CP	04.06.28
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.03.24		

DART AEROSPACE LTD

HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

D3294

REV. C

SHEET 1 OF 6

TITLE

BRACKET

NTS

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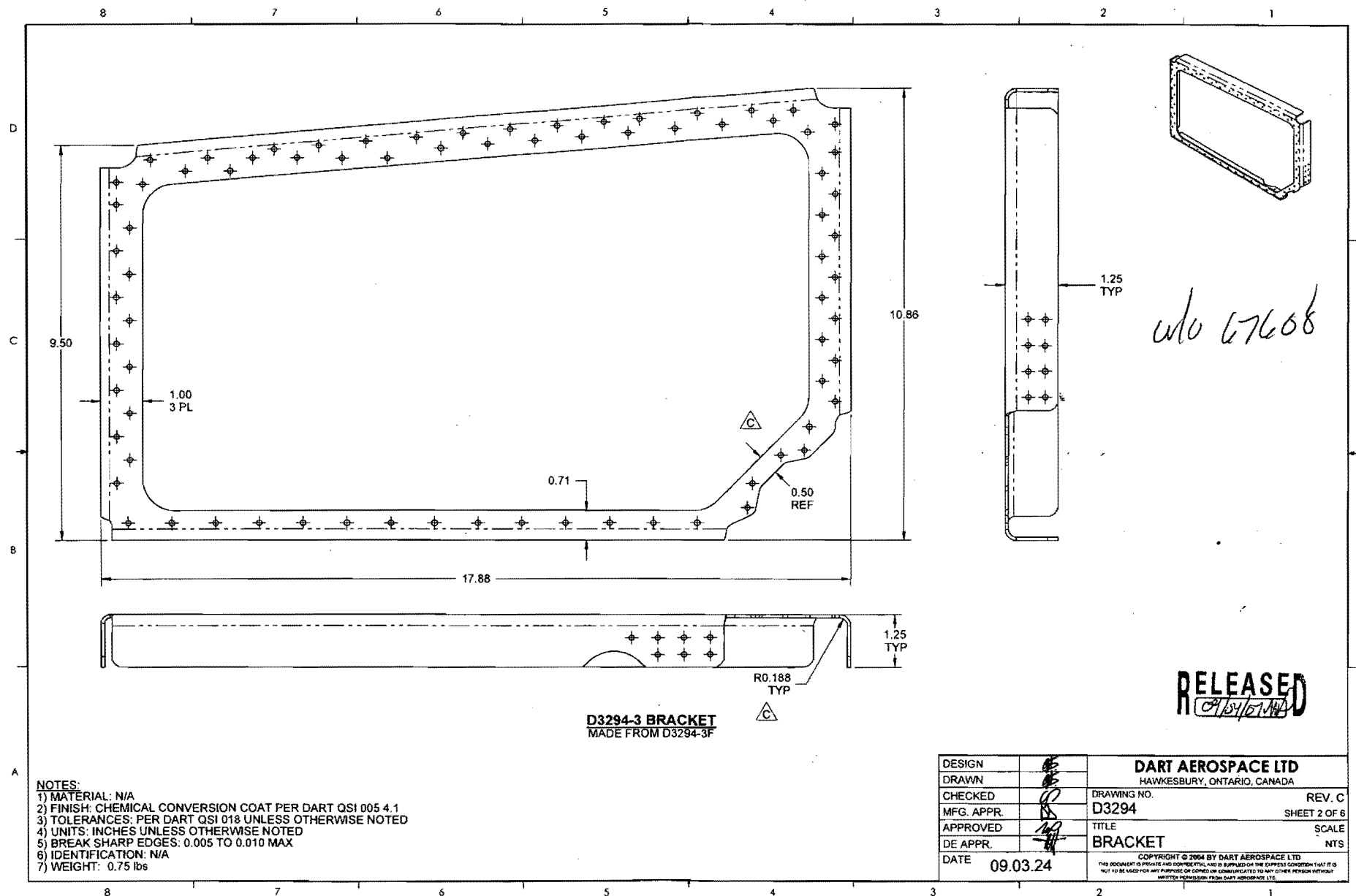
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NOTE: Date & initial all entries



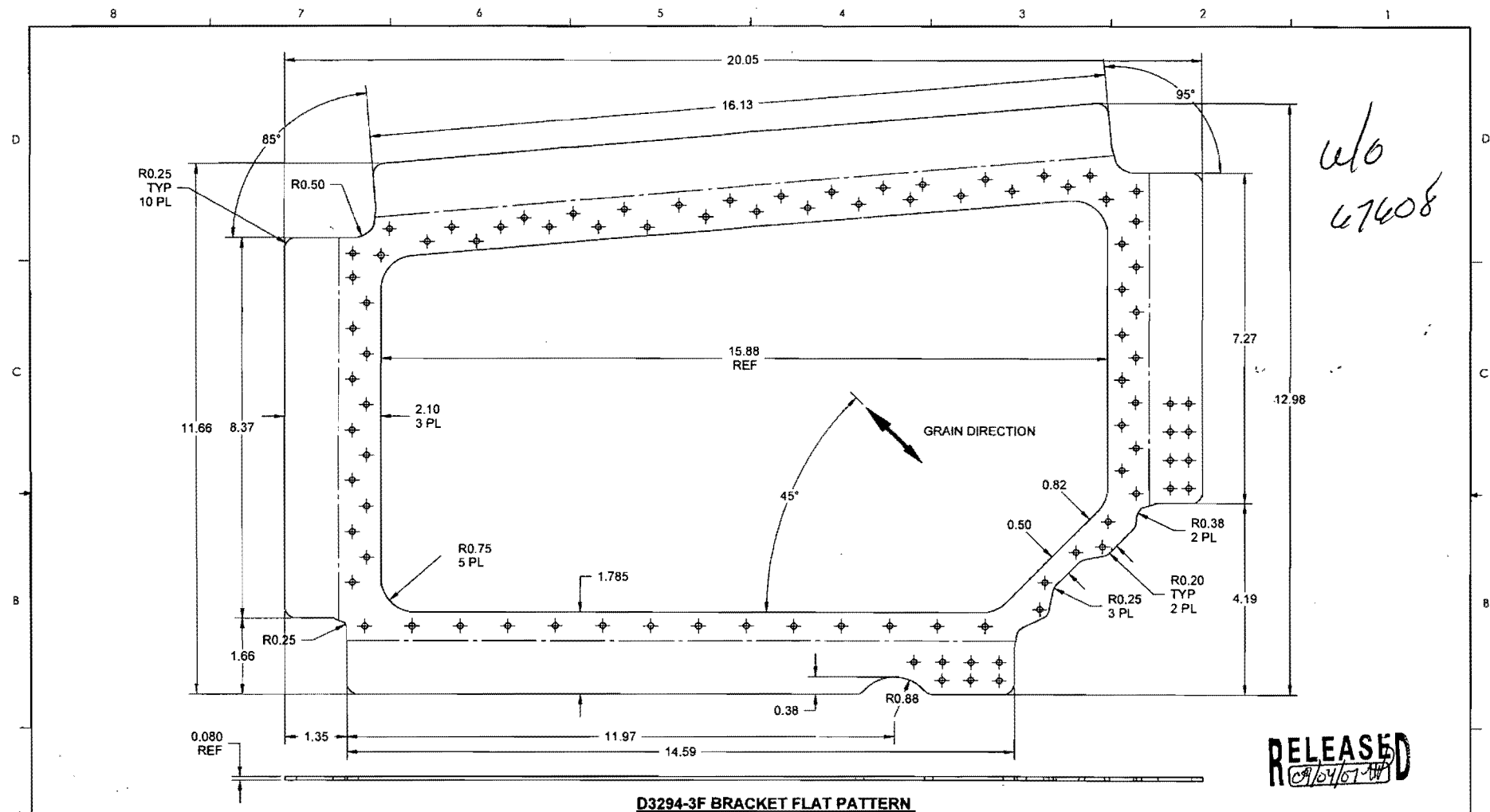
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3294-3F BRACKET FLAT PATTERN

RELEASED
09/04/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.75 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE REPRODUCED OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

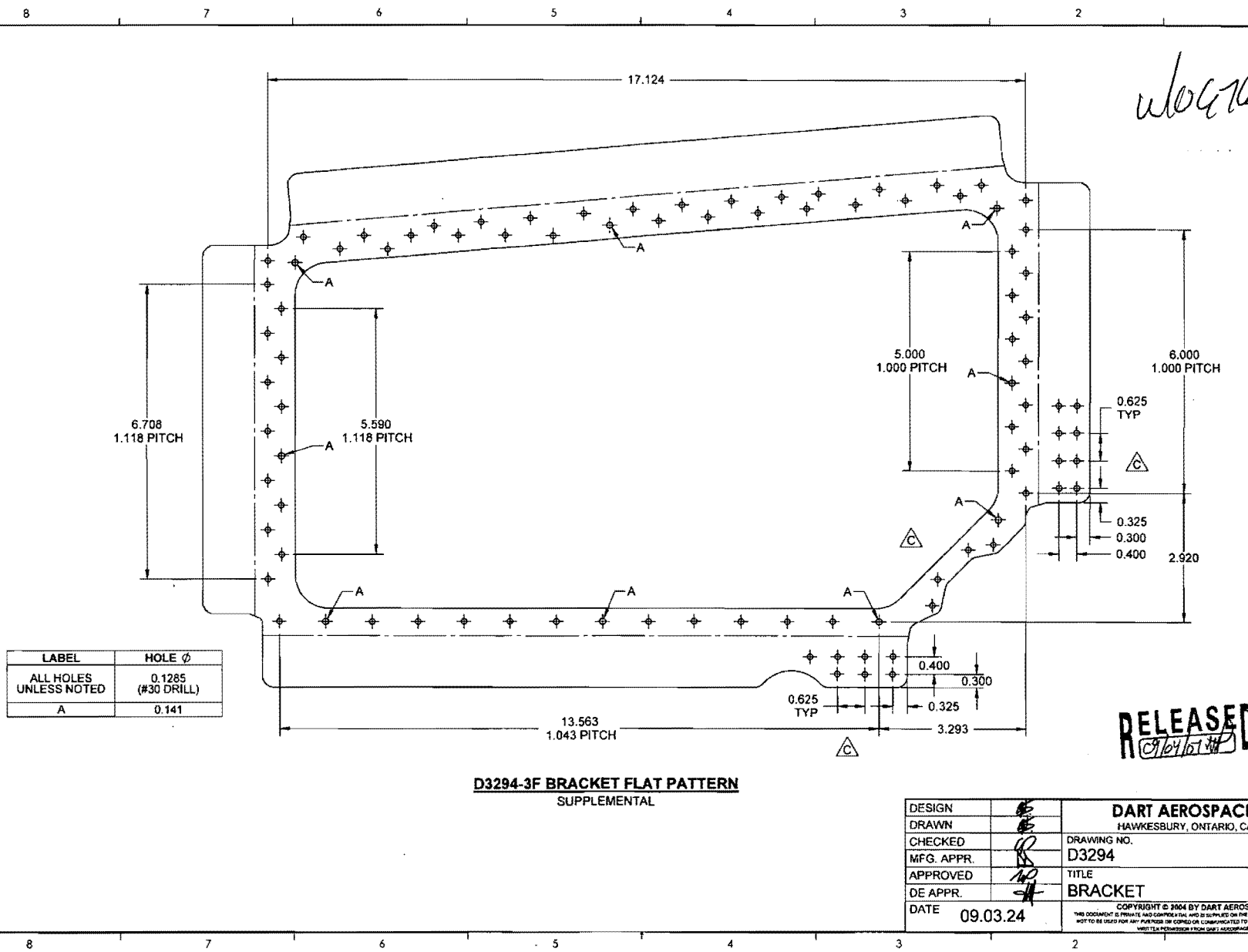
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NOTE: Date & initial all entries



W067608

LABEL	HOLE ϕ
ALL HOLES UNLESS NOTED	0.1285 (#30 DRILL)
A	0.141

D3294-3F BRACKET FLAT PATTERN
SUPPLEMENTAL

RELEASED
09/04/01

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3294	REV. C
MFG. APPR.		TITLE	SHEET 4 OF 6
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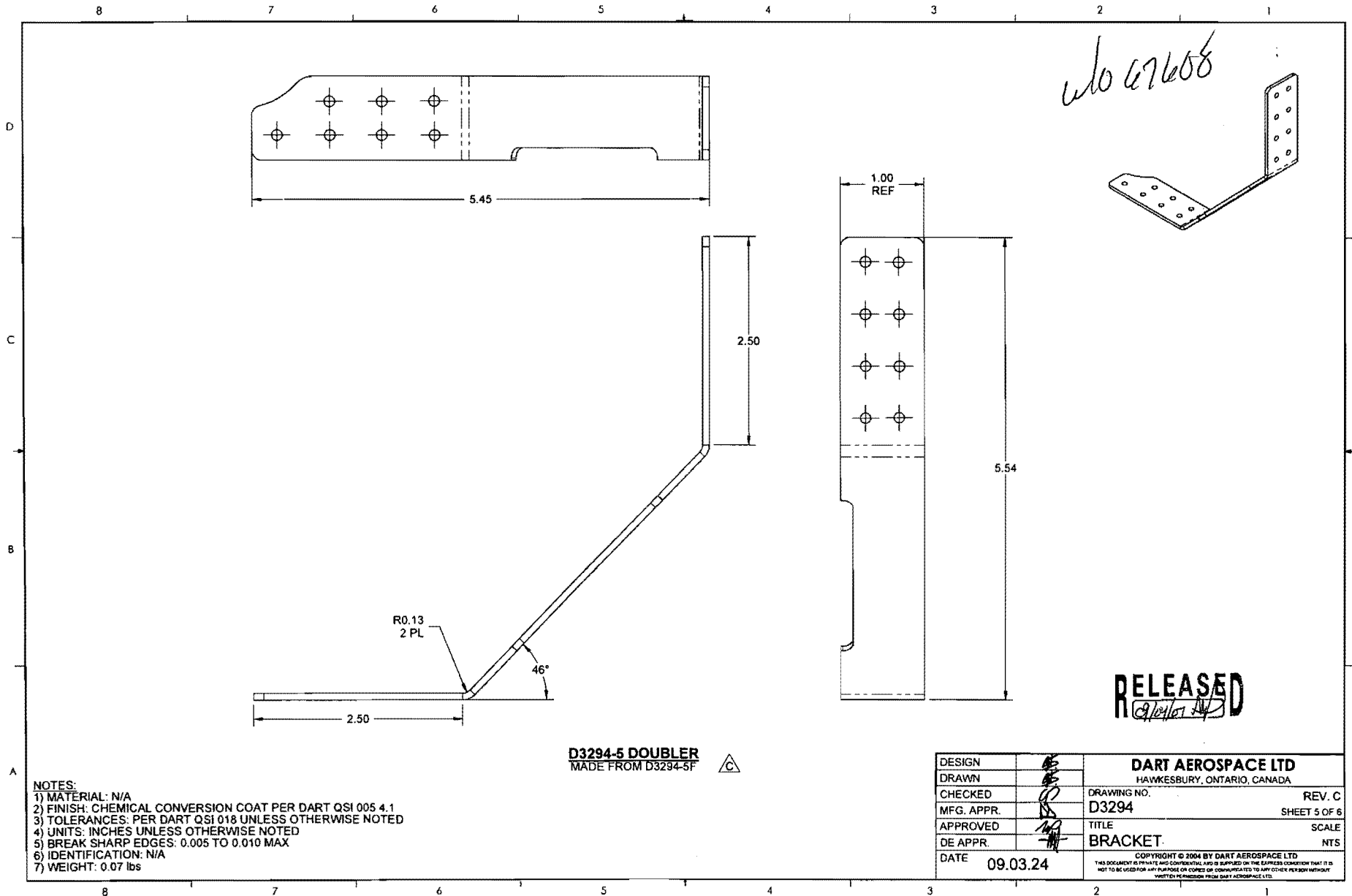
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NOTE: Date & initial all entries









who 67608

RELEASED

D3294-5 DOUBLER
MADE FROM D3294-5F



- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 5 OF 6
APPROVED		TITLE	SCALE
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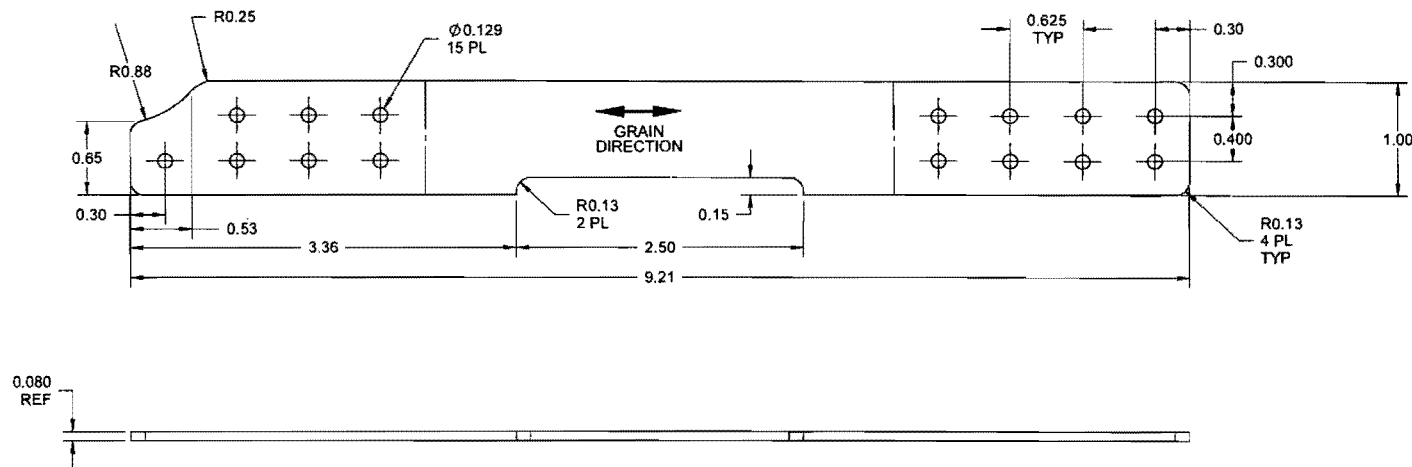
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

u/c 67608



D3294-5F DOUBLER FLAT PATTERN



RELEASED
9/6/07

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.080 THICK PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.080)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.07 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3294	SHEET 6 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	09.03.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries